

Date: Monday, 16/03/2009 11:35:04 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ANGLE
Job Number :	46504		
Estimate Number :	12751		
P.O. Number :		Part Number :	D36021
This Issue :	16/03/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3602 REV.B
First Issue :	/ /	Project Number :	N/A
Previous Run :	44148	Drawing Revision :	B
	Type :	Material :	
	SMALL /MED FAB	Due Date :	23/03/2009
Written By :			Qty: 1 Um: Each
Checked & Approved By :			
Comment :	Est Rev:A New Issue 07-02-27 JLM Est Rev:B 08-12-11 as per ECN08-577 DD verified by:EC Est Rev:C 09-03-16 rev.b as per dwg DD verified by:JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.6206 sf(s)/Unit ~~Total: 0.6206 sf(s)~~
 304/316 .040" Sheet
 Batch: 110076

ml 09 03 16 ①

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3602
 Dwg Rev: B
 Prog Rev: B

2-Deburr if necessary

ml 09 03 16 ①

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 03 16

①

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

090317 ①

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 1- bend 70 degree angle as per dwg D3602
 2- Form radius (curve) as per Dwg D3602

SB 09/05/2000 ①
 FF 09-05-20 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 16/03/2009 11:35:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 46504

Part Number: D36021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

809/05/20 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock
Location: 57241A

809/05/21 (2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/26 HJ

Job Completion



U 09.05.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	46504
Description: ANGLE	Part Number:	D3602-1
Inspection Dwg: D3602 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

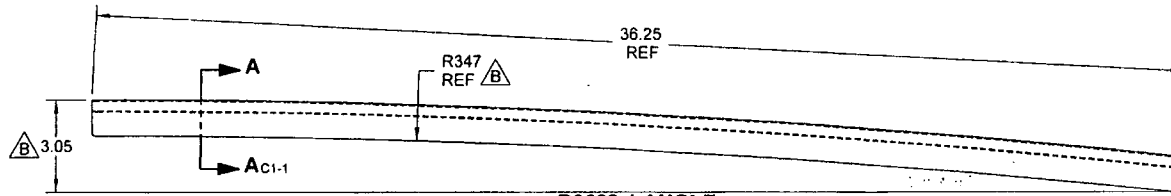
X	First Article	Prototype
---	---------------	-----------

[illegible]

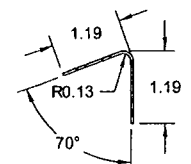
Measured by:	<i>ml. ml</i>	Audited by:	<i>/</i>	Prototype Approval:	
Date:	<i>09 03 16</i>	Date:	<i>05 03 17</i>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

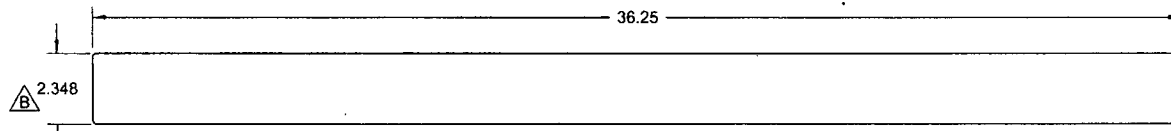
8 7 6 5 4 3 2 1



D3602-1 ANGLE
(MAKE FROM D3602-1F)



SECTION A-A
SCALE 2X



D3602-1F FLAT PATTERN

R0.13
TYP

RELEASED
08/03/11

46504

REFERENCE ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK, PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3602-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs

B	ADDED ROUNDED SHAPE: R347 REF AND 3.05; 2.348 WAS 2.328. REF: NCR#09-014	MB	09.02.02
A	NEW ISSUE	MB	07.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.02.02		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3602** REV. B
SHEET 1 OF 1

TITLE **ANGLE** SCALE
NTS

COPYRIGHT © 2007 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1